

Work Order ID 75500

Monday, October 24, 2011 10:24:32 AM

75500

Page 1

of 27
UNALIKE

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Lock Assembly
 Start Date: 10/24/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/27/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 11-10-24 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3371	Rev B

120

120

Small Fab

Small Fab

Small Fab

Memo

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>M117951</u>

SS 11/10/27

①

130

130

Small Fab

Small Fab

Small Fab

Memo

Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-045

SS 11/10/27 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75500***75500***

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Monday, October 24, 2011 10:24:32 AM

Item ID: D3371-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Lock Assembly

Start Date: 10/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/27/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

Small Fab

Small Fab

Memo

0.00

- 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.
2- Identify as D3371-041 & attach keys
3- Record the Key Number on page 4

SP 4/10/27

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SP 4/10/27

4/1

160

160

Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

CRISA

4/10/27 SP

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, October 24, 2011 10:24:31 AM

Page 1

Work Order ID: 75500

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 10/24/2011

Required Date: 10/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 3/16" Dowel Pin .5" long		Purchased	No			120	Each	222.0000	2	2		11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		222							
				106673		98							
				108114		97							
				17848		27							
AN526C832R6 Screw		Purchased	No			120	Each	330.0000	4	4		11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		330							
				16612		330							
AN960-416 Washer	NAS1149F0463P	Purchased	No			140	Each	0.0000	2	2		11/10/27	
CBL-1240 Cable		Purchased	No			130	f	923.0014	1.6666	1.7543158		11/10/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		500							
				119021		500							
				ST284		423.001431							
				113565		3.911789							
				116438		119.089642							
				118207		300							

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Picklist Print

Monday, October 24, 2011 10:24:31 AM

Page 2

Work Order ID: 75500

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 10/24/2011

Required Date: 10/27/2011

Start Qty: 1.00

Required Qty: 1.00

CBL-460	Purchased	No	130	Each	439.0000	2	SB 2 11/10/27
Loop Sleeve							

Location	Loc Qty	Loc Code
GA	200	
119021	200	
ST283	13	
117947	13	2
ST284	226	
118140	226	

D2728-7	Manufactured	No	120	Each	0.0000	0	SB 0 11/10/27
Dart Logo label							

D3371-1	Manufactured	No	120	Each	1.0000	1	SB 1 11/10/27
Pedal Lock Base							

Location	Loc Qty	Loc Code
ST485	1	
70040	1	

D3371-3	Manufactured	No	120	Each	0.0000	1	SB 1 11/10/27
Pedal Lock Cover							

D3373-7	Manufactured	No	120	Each	0.0000	1	SB 1 11/10/27
Cam Lock							

D3384-1	Manufactured	No	130	Each	0.0000	1	SB 1 11/10/27
Cyclic Sock							

D3385-3	Manufactured	No	120	Each	101.0000	1	SB 1 11/10/27
Hinge							

Location	Loc Qty	Loc Code
ST051	101	
22387	101	7

HX-81	Purchased	No	140	Each	17.0000	1	SB 1 11/10/27
1/4"-20 SHCS 3/8" long							

Location	Loc Qty	Loc Code
ST390	17	
114383	17	1

Monday, October 24, 2011 10:24:32 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

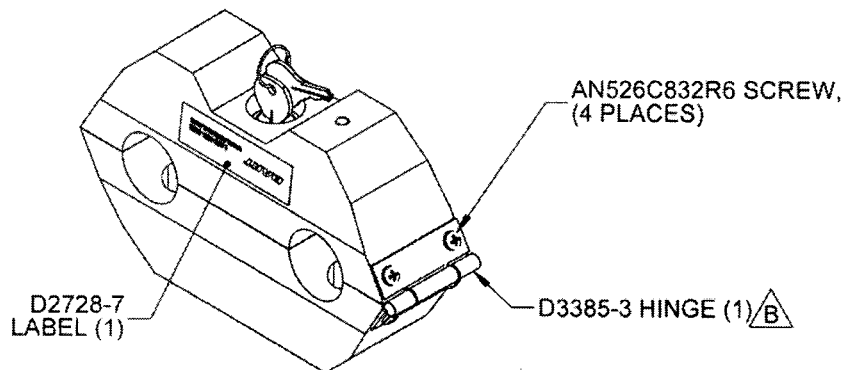
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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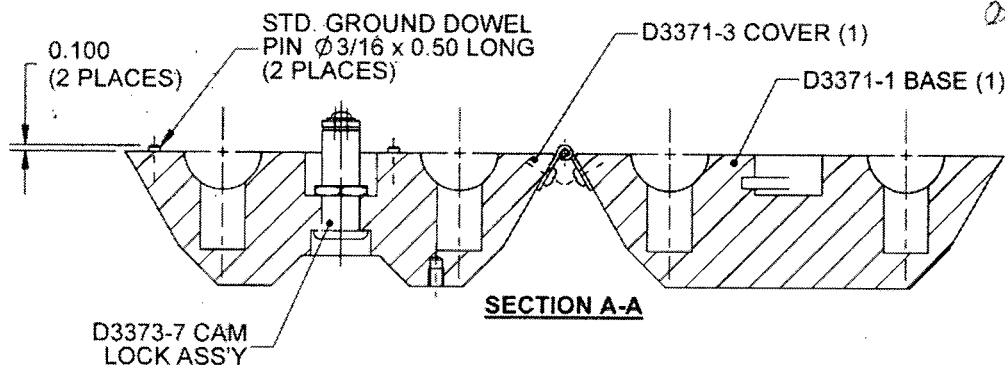


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

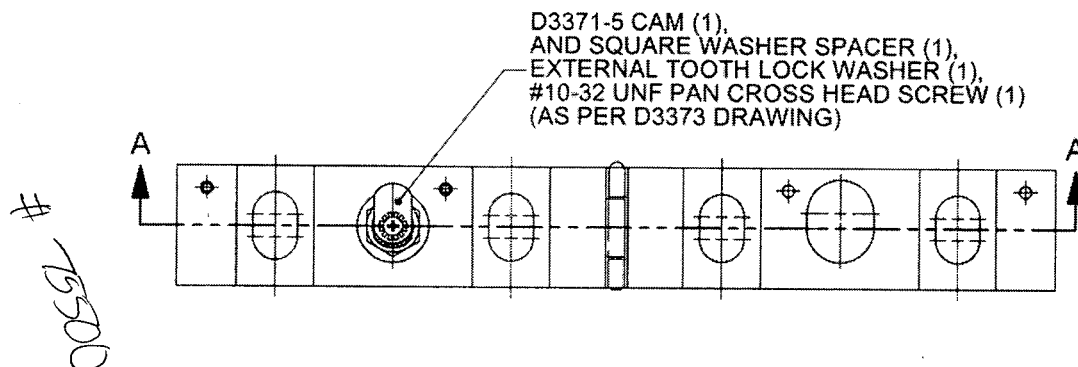


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

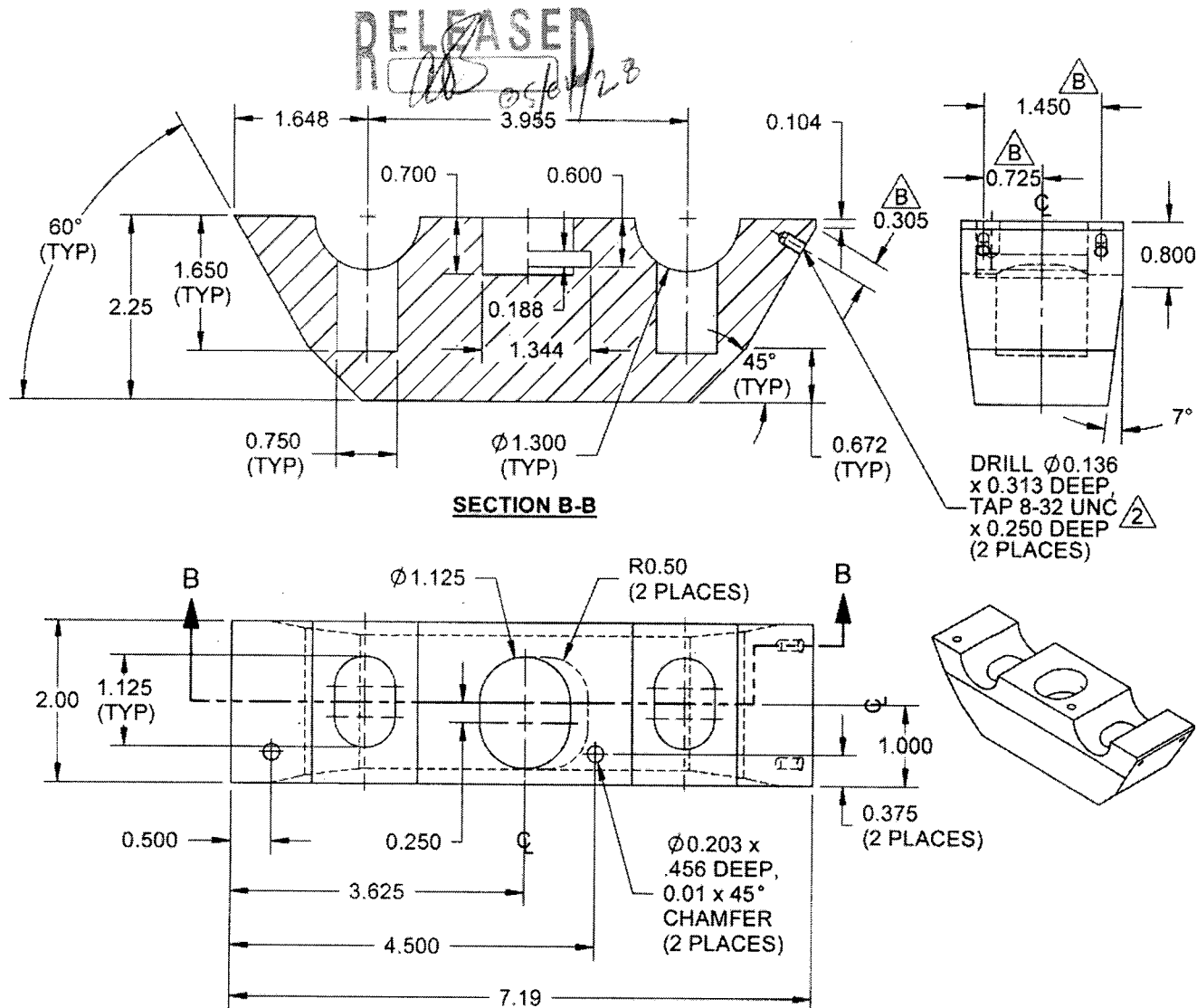
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 45	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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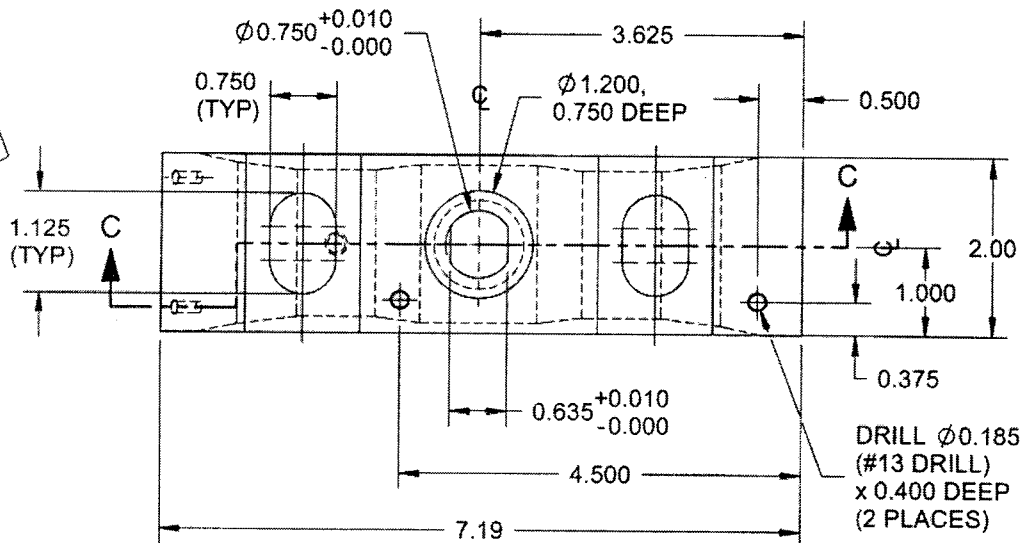
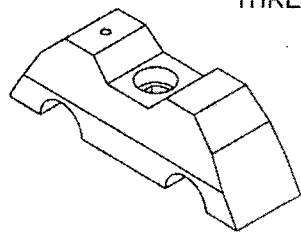
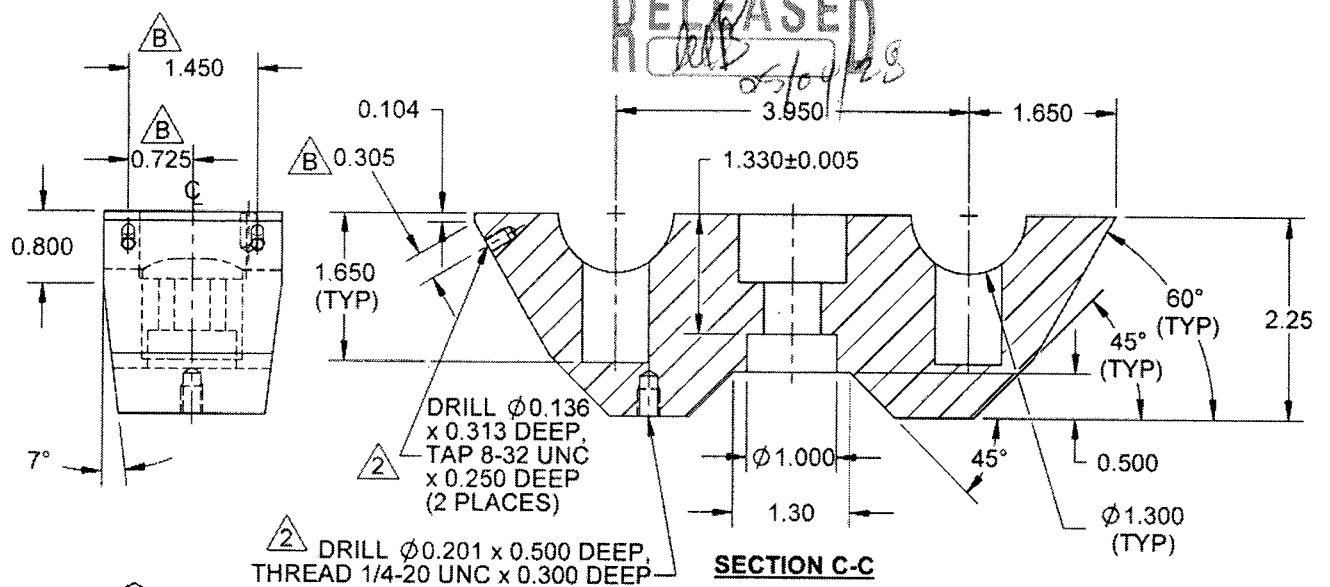
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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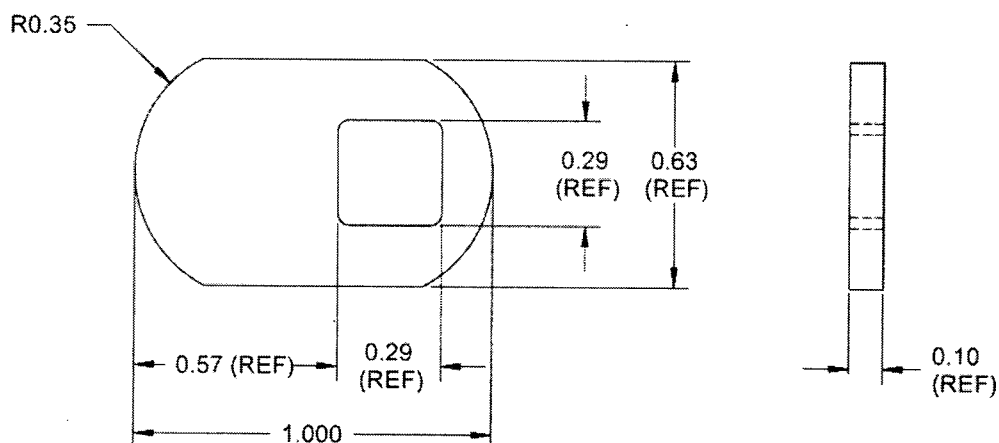
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/20

SPECIFICATION CONTROL DRAWING



#75300

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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